

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021251**Date Inspected:** 08-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Shi Gao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

: On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 12CW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2F position of weld # CA3012-164 of Counterweight side Drip plate.

The welder is identified as 067829. ZPMC CWI is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with the WPS B-P-2112-FCM-1.

OBG Segment 12BE

This QA Inspector observed the following work in progress:

During in process inspection this QA Inspector observed ZPMC NDT personnel performing Ultrasonic Testing (UT) on Counterweight side Longitudinal Diaphragm (LD) to Bottom Panel weld between PP112 and 112.5 after repair. See attached photograph Pic_001.

OBG Segment 12AW

WELDING INSPECTION REPORT

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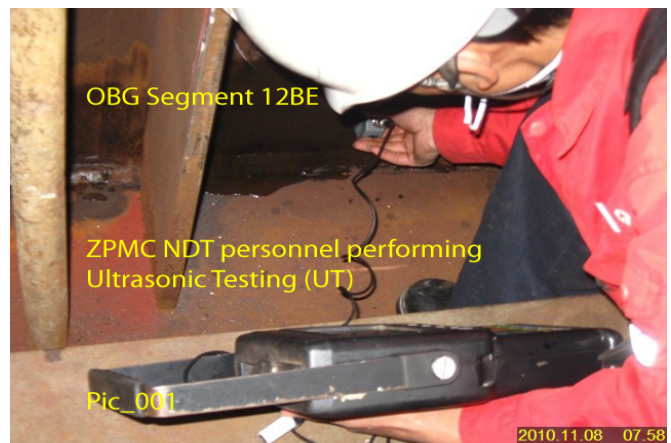
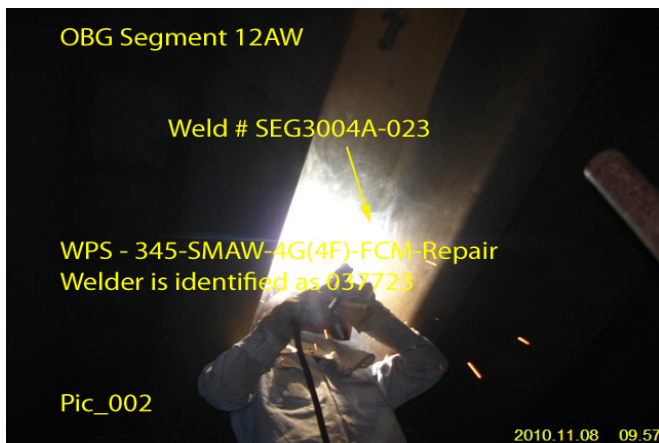
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3004*-022 of Deck Panel as per repair report # B-WR 16583. The welder is identified as 067609. ZPMC CWI is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with the WPS 345-SMAW-4G(4F)-FCM-Repair.

OBG Segment 12AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3004A-023 of Deck Panel as per repair report # B-WR 16584. The welder is identified as 037723. ZPMC CWI is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with the WPS 345-SMAW-4G(4F)-FCM-Repair. See attached photograph Pic_002.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
